

SHIP ASAP

Dart Aerospace Ltd.

Date: Tuesday, 11/21/2006 10:44:47 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 29552	
Estimate Number : 10709	
P.O. Number : N/A	Part Number : D32101
This Issue : 11/21/2006 S.O. No. : N/A	Drawing Number : D3210 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 29013	Material : N/A
Written By : <u>JA 06 11 21</u>	Due Date : 11/23/2006
Checked & Approved By : <u>JA 06 11 21</u>	Qty: 4 Um: Each
Comment : Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now On Waterjet 06-10-24 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
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Comment: Qty.: 2.6177 sf(s)/Unit Total : 10.4706 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)Identify as D3210-1  
Batch: m17695 ml 06 11 21

(4)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3210

~~3~~ \*\*\*ATTN: NO HOLES\*\*\* ~~4~~

Dwg Rev: A  
Prog Rev: A

ml 06 11 21

(4)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 11 21

(4)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06-11-21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 04/11/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 10:44:47 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 29552

Part Number: D32101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

FF 06-11-22 4

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

YH FC 06/11/22 x4

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 11 22 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 6/11/23 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 5789

PC 6/11/23 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 06/11/23 (4)

Job Completion



U 11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

[illegible]

<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
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~~\* Note: This Batch only Jan/10-11-21 \*~~

2  
A.11.2

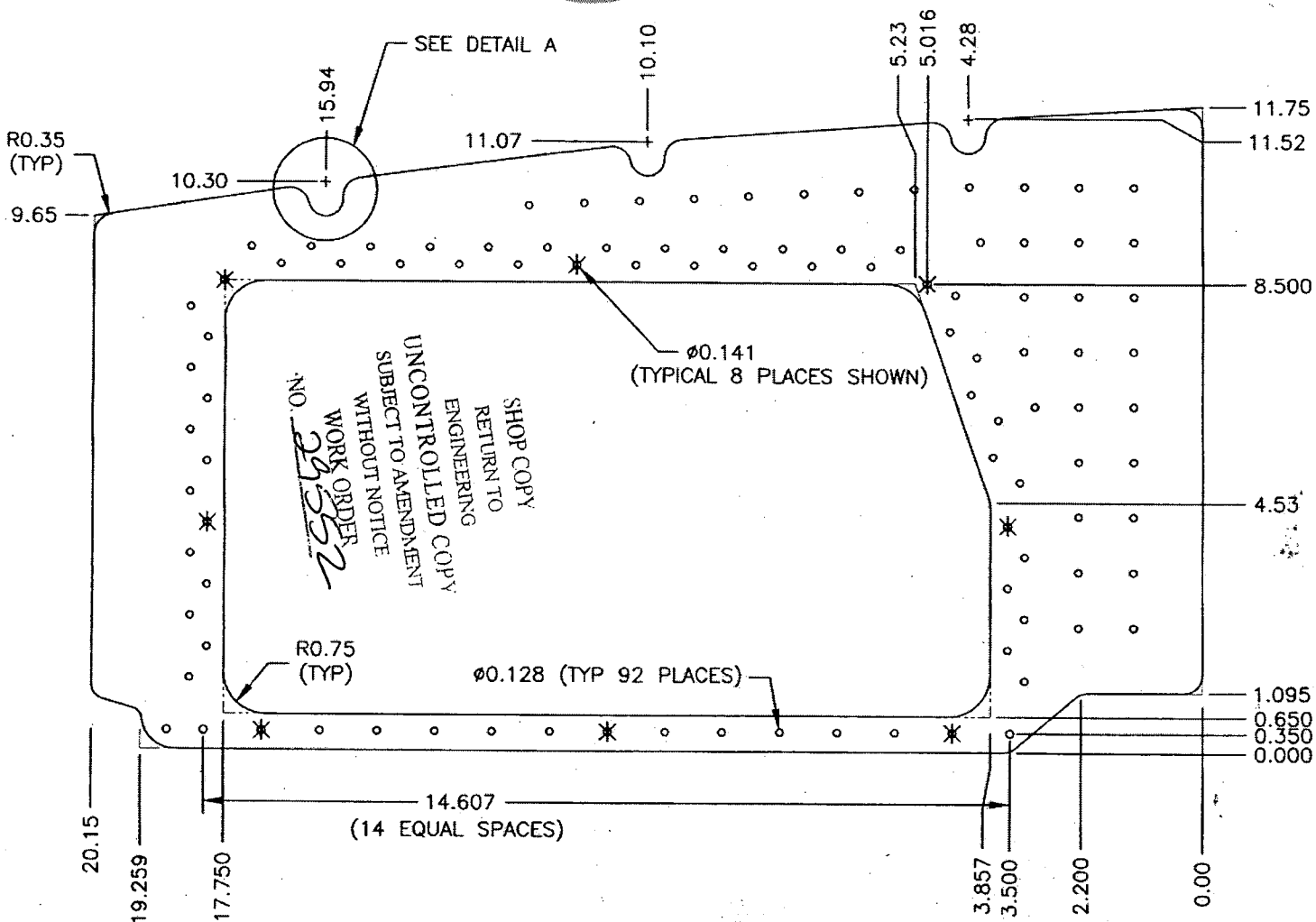
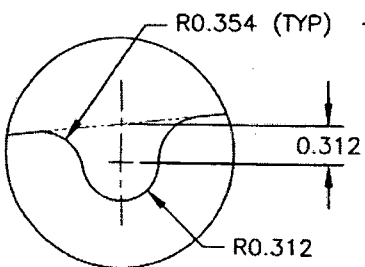
Handwritten signatures: *KA* and *Paul*

QA COPY ISSUED

DESIGN	DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
03.09.03	03.09.03	D3210	SHEET 1 OF 1	
DATE	TITLE		SCALE	
03.09.03	DOUBLER		1:3	
A	03.09.03		NEW ISSUE	

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03-09-15



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